

[CLAIMS]

1. An injection molding machine comprising a toggle type mold clamping apparatus which is disposed between a movable platen mounted with a movable side mold and a rear platen and which moves the movable platen forward and rearward by a mold clamping servo-motor; and

mold clamping force adjusting means which adjusts a position of the rear platen according to a difference between a mold clamping force obtained by measurement every predetermined number of molding cycles or an average of such mold clamping forces and a predetermined reference mold clamping force.

2. The injection molding machine according to claim 1, wherein the reference mold clamping force is an average value of a plurality of mold clamping forces acquired by performing a plurality of molding cycles.

3. The injection molding machine according to claim 1, wherein the mold clamping force is a load applied to the mold clamping servomotor measured during mold clamping.

4. The injection molding machine according to claim 1, wherein the mold clamping force is a load applied to the mold clamping servomotor obtained by measurement conducted during mold clamping.

5. The injection molding machine according to claim 3 or 4, wherein the load of the mold clamping servomotor is detected on the basis of a current value of the mold clamping servomotor.

6. The injection molding machine according to claim 3 or 4,

wherein the load of the mold clamping servomotor is detected by an observer provided to the mold clamping servo-motor

7. An injection molding machine comprising a toggle type mold clamping apparatus which is disposed between a movable platen mounted with a movable side mold and a rear platen and which moves the movable platen forward and rearward by a mold clamping servo-motor; and

mold clamping force adjusting means which adjusts a position of the rear platen according to a difference between a load of the mold clamping servo motor obtained by measurement every predetermined number of molding cycles or an average of such loads and a predetermined reference load of the mold clamping servomotor.

8. The injection molding machine according to claim 7, wherein the reference load of the mold clamping servomotor is an average value of a plurality of mold clamping forces acquired by performing a plurality of molding cycles.

9. The injection molding machine according to claim 7, wherein the load of the mold clamping servomotor is a load applied to the mold clamping servomotor during mold clamping.

10. The injection molding machine according to claim 7, wherein the load of mold clamping servomotor is a load applied to the mold clamping servomotor when the mold clamping force is unclamped.

11. The injection molding machine according to claim 7, wherein the load of the mold clamping servomotor is detected on the basis of a current value of the mold clamping servomotor.

12. The injection molding machine according to claim 7, wherein the load of the mold clamping servomotor is detected by an observer provided to the mold clamping servomotor.

13. The injection molding machine according to claim 1 or 7, wherein, when an adjustment amount of the position of the rear platen for one molding cycle or an accumulation of such adjustment amounts exceeds a predetermined adjustment amount, alarm is outputted.